

Date: Wednesday, 15/04/2009 10:10:54 AM
 User: Melanie Fauteux

Process Sheet

RUSH

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 47218
 Estimate Number : 13851
 P.O. Number :
 This Issue : 15/04/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : SMALL /MED FAB
 Previous Run :
 Written By :
 Checked & Approved By : MF 09-04-15
 Comment : Est Rev:A New Issue 09.04.14 EC verified by:DD

Part Number : D35703
 Drawing Number : D3570 REV D PRELIM ASS
 Project Number : N/A
 Drawing Revision : D PRELIM 09.04.13
 Material :
 Due Date : 17/04/2009 Qty: 1 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.0746 sf(s)/Unit Total : 0.0746 sf(s)
 6061-T6 .125 Sheet
 Batch: 110062 IB 9-4-16

Grain must be Along 4.63"**

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3570
 Dwg Rev: PRF
 Prog Rev: Lim

IB 9-4-16

(2)

2-Deburr if necessary IB 9-4-16

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-4-16

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

09-04-16 (2)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D3570 Using DT8945

(2)

FF 09-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/04/2009 10:10:54 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47218

Part Number: D35703

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut excess material per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

FF 09-04-16 (2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

ASS 09.04.17 20.04.17 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMP/9A

09/04/17 (X2)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 10:00am

OVEN TEMPERATURE: 320°C

FINISH TIME: 10:30am

9A 09-04-17

(X2)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09.04.17 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: ST 243A x 1 1 x P.O. #8437

8 09/04/17

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/17

Job Completion



0209109117

FIVE RECALL
09.04.17 AUTH 11
ASS DATE 09.04.17

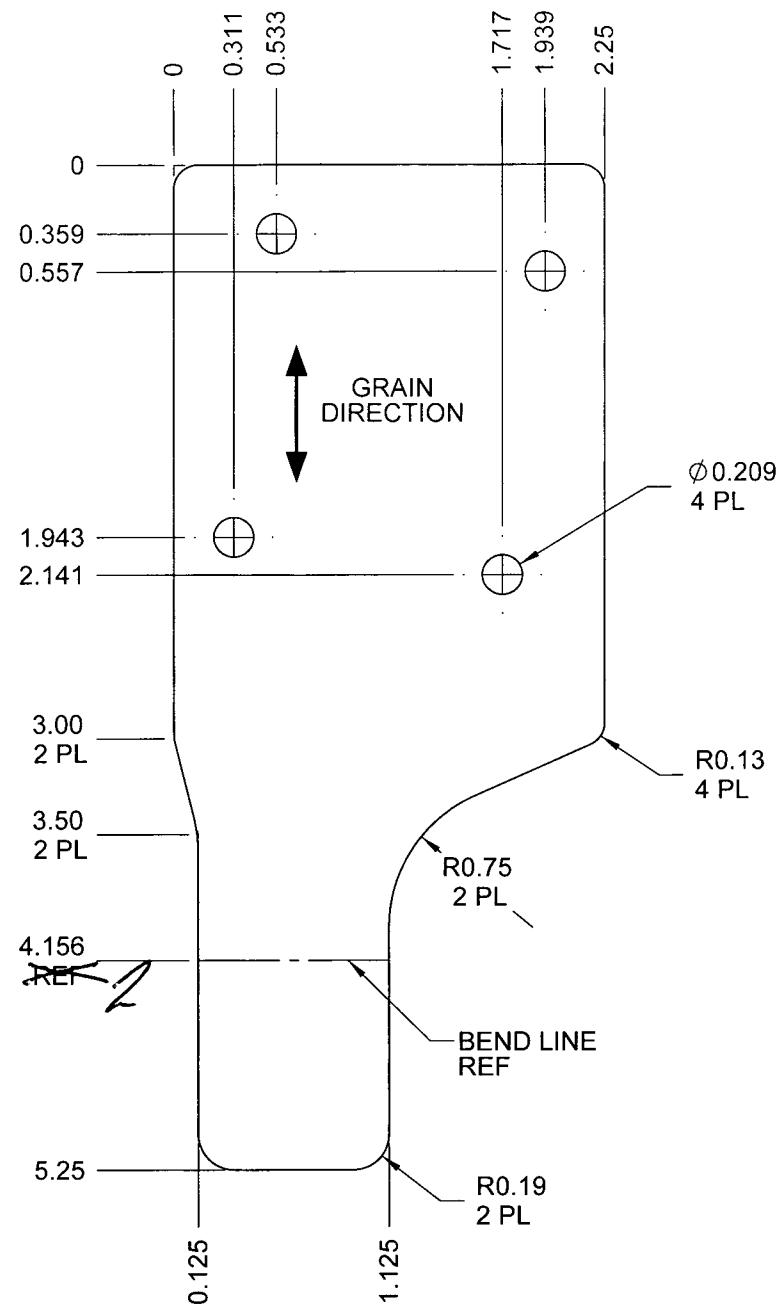
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

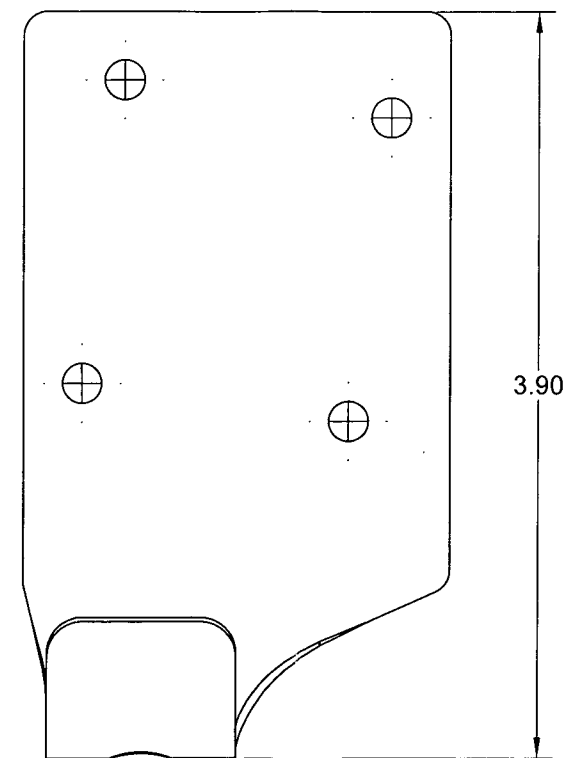
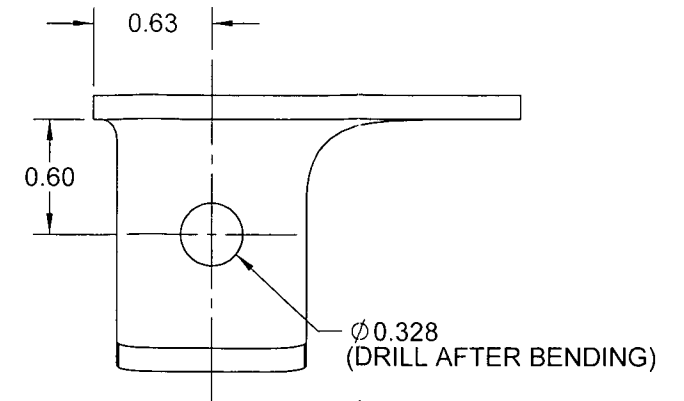
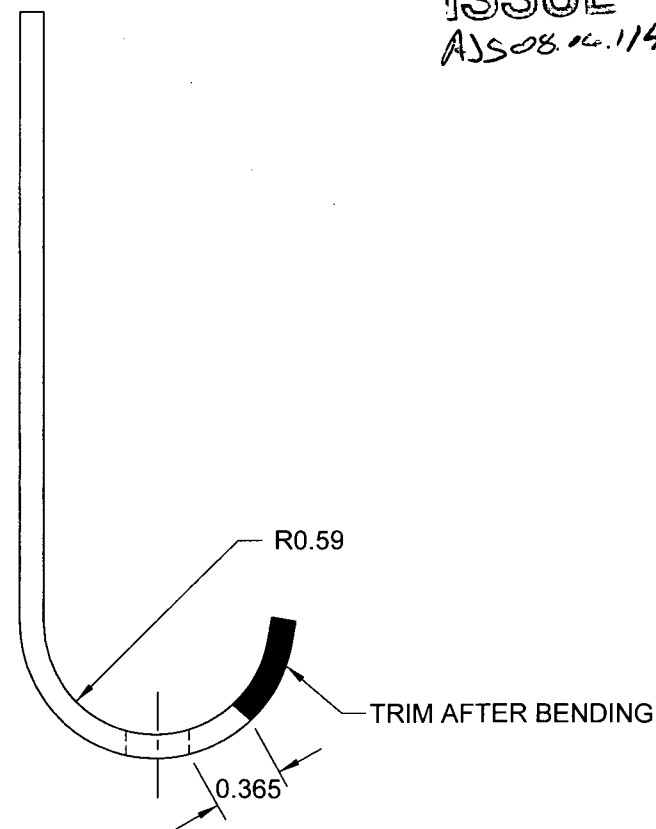
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3570-3F FLAT PATTERN

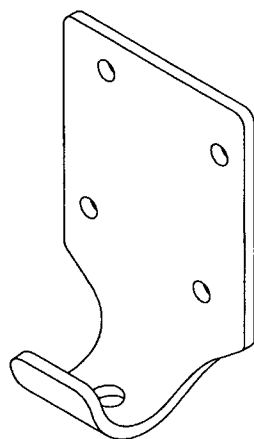
PRELIMINARY
ISSUE
AJS 08.16.114



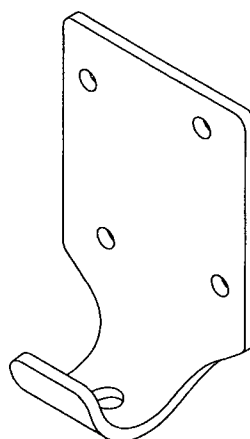
D3570-3 BRACKET
(MAKE FROM D3570-3F)

47218

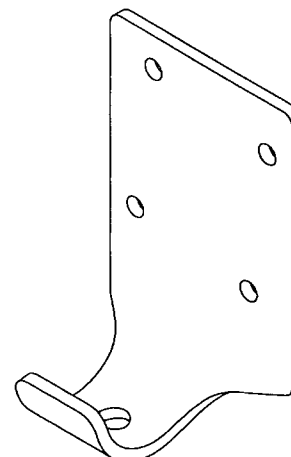
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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3570	SHEET 4 OF 5
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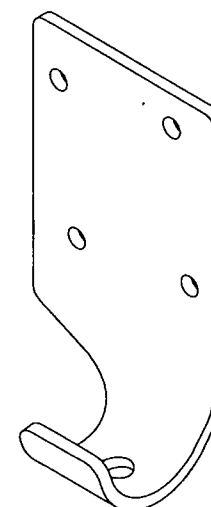
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

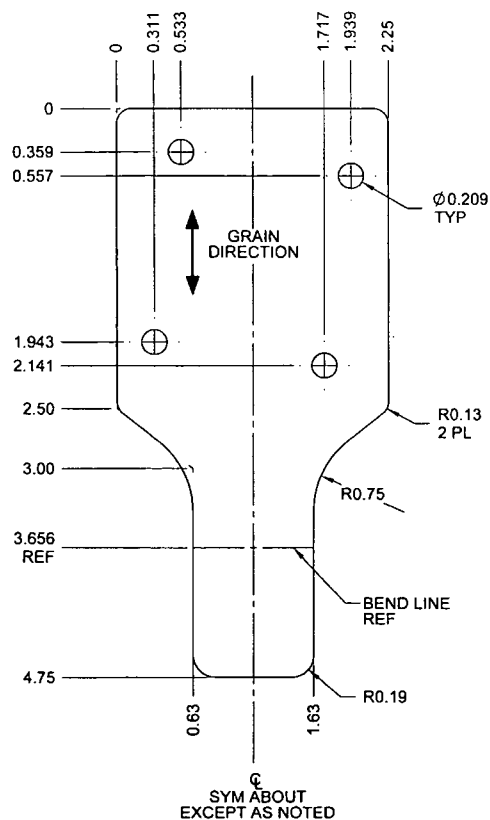
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NOTES:

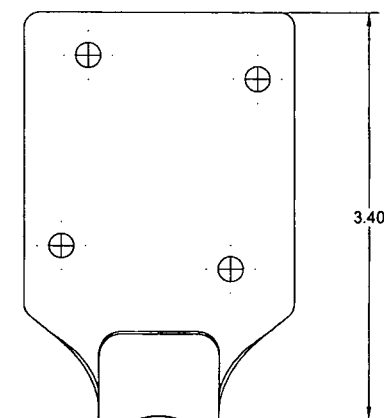
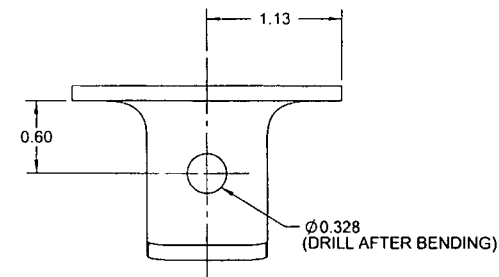
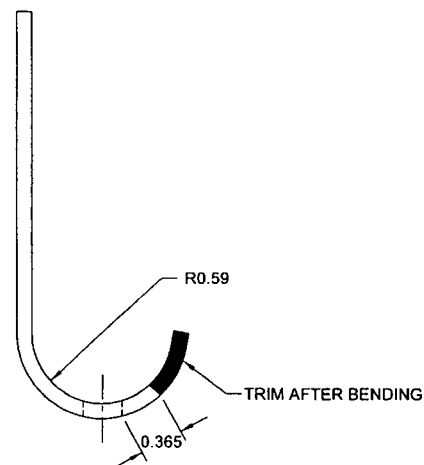
- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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D3570-1F FLAT PATTERN

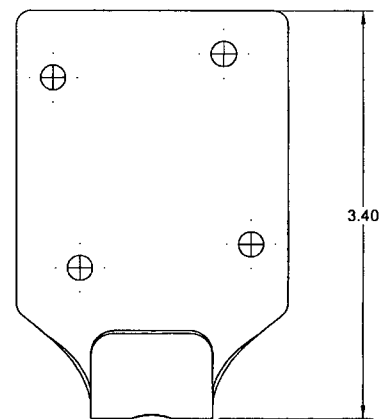
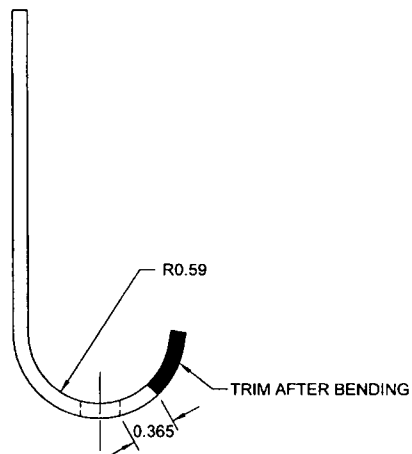
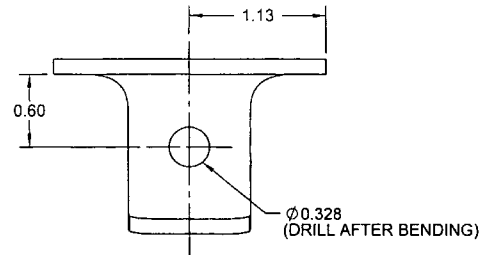
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D3570-1 BRACKET
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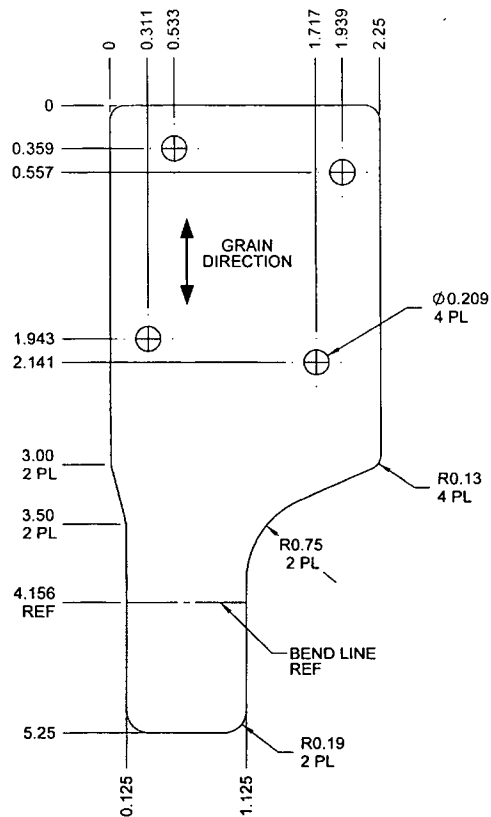


D3570-2 BRACKET
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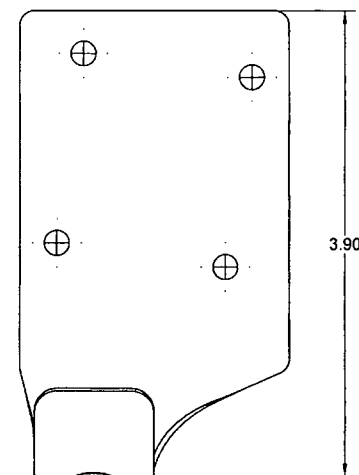
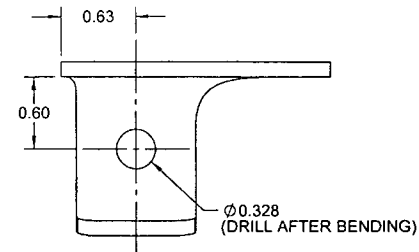
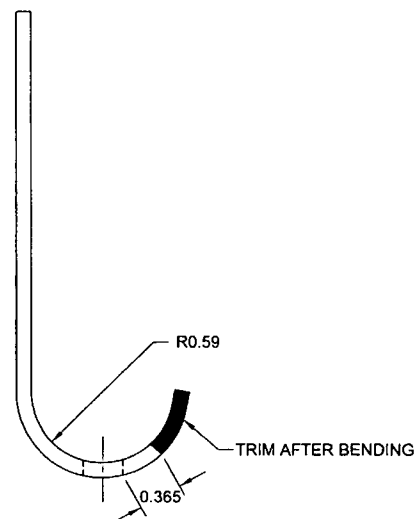
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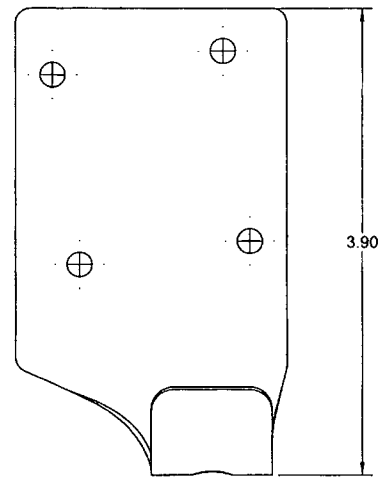
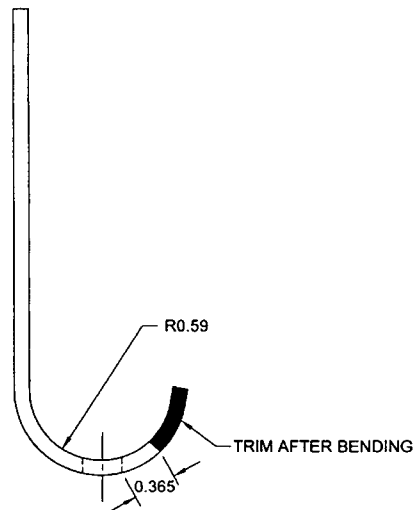
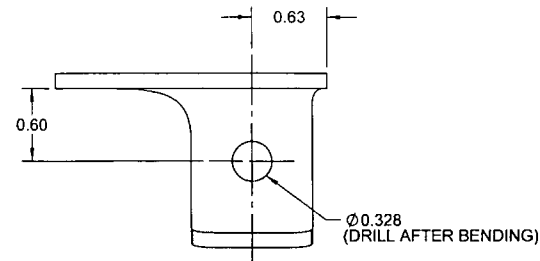
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